

Test for Robot

Work Order ID 132059

132059

Page 1

April-24-15 9:12:08 AM

Item ID: D4155-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar

Start Date: 24/04/2015 Start Qty: 16.00

16

Cust Item ID:

Required Date: 30/04/2015 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4155	E

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 92.00"

(EXTRA MATERIAL WILL BE CUT ON ASSEMBLY D4154-041)

16

Ø

DAS

44

9-89

15/04/26

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB048 & dwg D4155,

FOLIO REV: E

DWG REV: E

2-Deburr as required

16

Ø

DAS

44

9-89

15/04/27

DAS

20

9-89

15-04-28

Work Order ID 132059

132059

Page 2

April-24-15 9:12:08 AM

Item ID: D4155-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar
 Start Date: 24/04/2015 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 30/04/2015 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00				16	0		DAS 44 9-89 15/04/17
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: 105	0.00							
140									
Packaging	Memo	0.00							
Packaging									

CHARGE TO
 6L 16011-00
 FOR Robot Testing

132059

April-24-15 9:12:08 AM

N900040100

Setup Start *NS1*

Stop *NS2*

16

16

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

150

0.00

N/A

15-4-28

Picklist Print

Page 1

April-24-15 9:12:07 AM

Work Order ID: 132059

132059

Parent Item: D4155-1

D4155-1

Parent Item Name: Bar

Start Date: 24/04/2015

Required Date: 30/04/2015

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC
11.04.14 as per dwg revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.250x0.500

Purchased

No

100

f

298.8760

7.6333

129

DAS

M304B0 250x0 500

**

44
9-89

15/04/2015

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT009

298.876

m129366

28.696

m131205

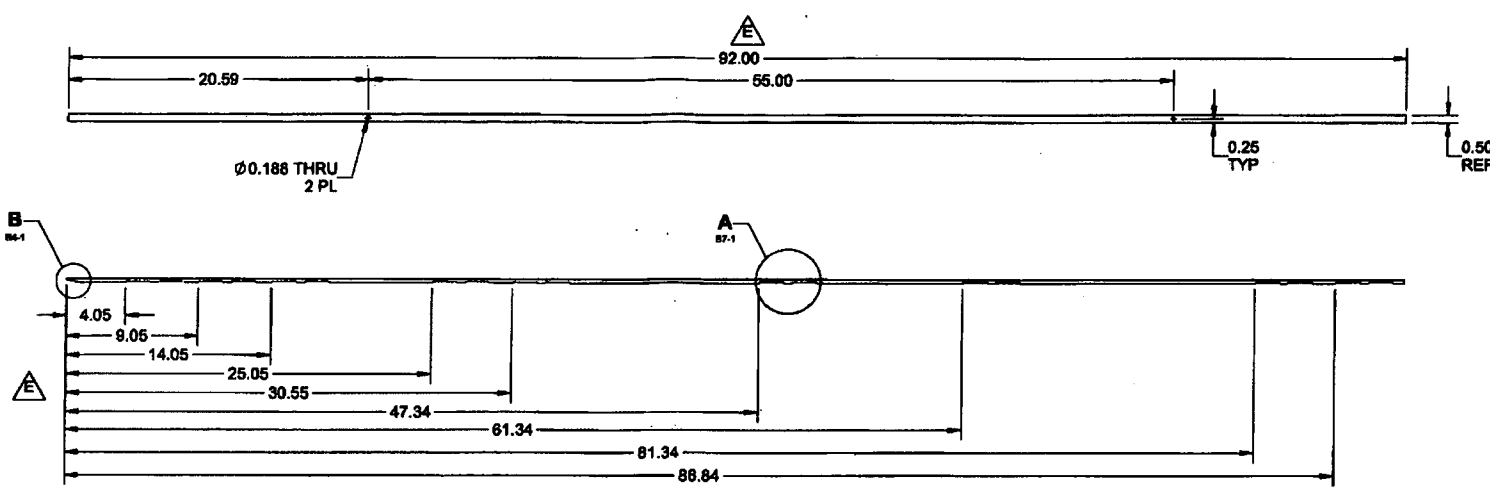
7.25

* m131748

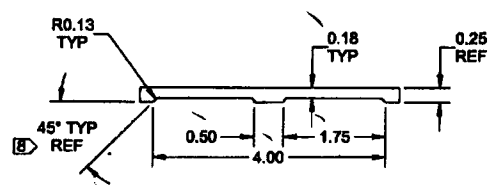
262.93

122.66

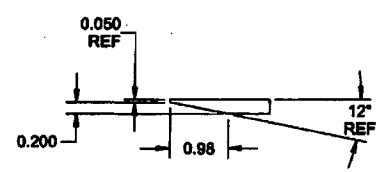
8 7 6 5 4 3 2 1



D4155-1 BAR



DETAIL A
SCALE 2X



DETAIL B
SCALE 2X

RELEASED
2013-08-13
wfp

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF. DART SPEC. M30480.250X0.500
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.98 lbs
 - 8) ANGLE TO BE DETERMINED BY AVAILABLE TOOLING.

E	DIMENSION DATUM ON OPPOSITE END OF PART; 92.00 WAS 91.50, REF CIR12-10	SFM	13.02.20
D	REDESIGNED WITH SHORTER CUTOUTS. NOTE 8 ADDED. (PAR 12-213); 0.18 WAS 0.13	AJS	12.08.07
C	REMOVED TOOLING HOLE; ADD CUT OUT PROFILE (2H C8-1 & C7-1); 2 DEC TOLERANCE (D1-1, D2-1)	RF	12.02.21
B	CHANGED MANUFACTURING PROCESS; MATERIAL WAS 0.50 THICK (A6-1); 0.26 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.06
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	SFM		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO. D4155 TITLE BAR	
DATE	13.02.20	REV. E SHEET 1 OF 1 SCALE NTS	

8 7 6 5 4 3 2 1

